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RBE703A95-0505-00-15
Job Sheet 197480



Part No: RBE703A95-0505-00-15

Job Qty: 20 pcs

Part Name: TGB Drain Tube Quill Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/9/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE703A95-0505 Rev M IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev. B 19.02.27 drawing revision DP Verify DD/IPP Rev. C 19.05.23 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
110	Small Fab - 1	20 pcs	9/2/19		0.00	4.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	20 pcs	9/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	20 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S203835



Part: RBE703A95-0505-00-15

Job No: 197480

Serial No/Batch: S203835

Revision: M

Inspector:

Exp Date:

Instructions:

Date: 08/08/19

DAS

40

AUG 12 2019 9-89

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA		20 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - 1-Cut RBE703A95-0505-00 -9 as per drawing sheet 4. 2-Cut RBE703A95-0505-00 -13 as per drawing sheet 8. 3-
 Descriptions: Assemble as per drawing note 7 and 8. 4-Pack as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1887T48	Oil-Resistant Buna-N Foam Sheet, 1" Thick, 40" x 68"	.2800 sf (.014 ea)	110-Small Fab - 1	5115377
2044T47	Tube Ø1.09	6.4000 ft (.32 ea)	110-Small Fab - 1	5199365
2044T67	Cap Ø1.09	40 Ea (2 ea)	110-Small Fab - 1	5172639
9263K173	O-Ring	20 Ea (1 ea)	110-Small Fab - 1	5199286
RBE703A95-0505-00-1	Quill	20 pcs (1 ea)	110-Small Fab - 1	5184827

Job Allocations

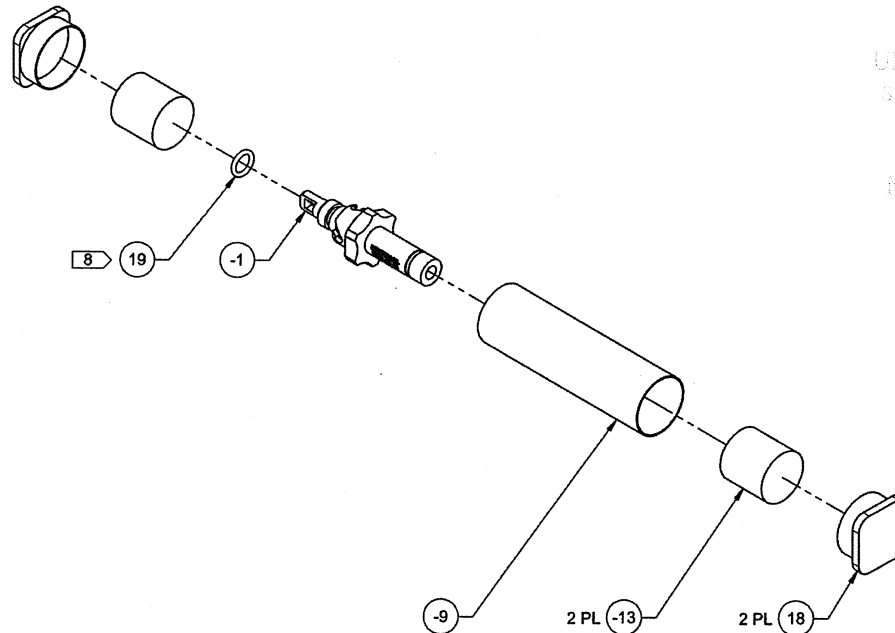
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1887T48	0	13	0
	2044T47	6	22	0
	2044T67	40	162	0
	9263K173	20	20	0
	RBE703A95-0505-00-1	20	36	0

Part Specifications

Specifications could not be found.

Plex 7/9/19 9:32 AM Dart.lajeunesse.marie

ITEM #	QTY	PART #	PART TITLE
-1	1	RBE703A95-0505-00-1	QUILL
-9	1	RBE703A95-0505-00-9	TUBE
-13	2	RBE703A95-0505-00-13	FOAM
18	2	McMaster#2044T67 OR EQUIV.	VINYL END CAP FOR 1.09" ID. SHIPPING TUBE
19	1	McMaster#9263K173 OR EQUIV.	VITON O-RING 9 mm ID. X 13 mm OD. X 2 mm WD.



RBE703A95-0505-00-15 TGB DRAIN TUBE QUILL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 19 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197480 HUS
19-07-09

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RBE703A95-0505-00 TITLE TGB DRAIN TUBE COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. M
DRAWN	MBB		SHEET 2 OF 6
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED	<i>[Signature]</i>		SCALE NTS
DATE 4/24/2019			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>197480</u> Part No. <u>RBE703A95-0505-00-15</u> <u>REV. M</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐					
Date: <u>2019-08-08</u>		Sequence #: _____		QTY Affected : _____			MRB (QS1042) 		
Description Work Order Deviation ITEM -13 MATERIAL WAS MCMASTER #1887T48 IS NEW PIC #PAD210				Disposition THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED			Completed By 		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
				Other/Details: _____					